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TITLE OF THE INVENTION
Solid Golf Ball

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This invention relates to solid golf balls having improved flying performance.

BACKGROUND OF THE INVENTION

In general, solid golf balls include a one-piece golf ball which is integrally molded in its entirety, a two-piece golf ball having a core enclosed in a cover, and a multi-layered golf ball having a core enclosed in a cover through one or more intermediate layers.

These solid golf balls have an elastic portion in the form of a molded and vulcanized rubber compound as a portion, that is, a core in the case of multi-layered golf balls or as their entirety in the case of one-piece golf balls. For the purpose of improving the repulsion coefficient and impact resistance of the prior art rubber compositions from which the elastic portion was formed, attempts were made to blend a monomer having an unsaturated bond, typically an α,β -ethylenically unsaturated carboxylic acid metal salt as a co-crosslinking agent in polybutadiene or a similar base rubber. The co-crosslinking agent will graft or crosslink to the backbone of polybutadiene rubber under the action of a peroxide or similar co-crosslinking initiator, resulting in a three-dimensional crosslinked polymer, which can provide an adequate degree of hardness and durability for one-piece golf balls or multi-layered ' golf ball cores. Therefore, one-piece golf balls formed from rubber compositions having such a co-crosslinking agent blended and multi-layered golf balls having cores formed from rubber compositions having such a co-crosslinking agent

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: blended are known to exhibit satisfactory flying performance and durability.

Golf players have a continuous demand for better flying performance and it is thus desired to develop golf balls baving further improved flying performance.

SUMMARY OF THE INVENTION

Therefore, an object of the invention is to provide a golf ball having further improved flying performance.

Searching for an optimum additive for a rubber composition containing a base rubber, typically polybutadiene and an unsaturated carboxylic acid metal salt as a co-crosslinking agent, the inventors have found that when an organic sulfur compound and/or a metal-containing organic sulfur compound is added to the rubber composition, there is obtained a rubber composition which can be vulcanized into a rubbery elastomer having improved rebound resilience. If a one-piece golf ball or a multi-layered golf ball core is formed from this rubber composition, the resulting solid golf ball exhibits an increased initial velocity upon hitting and improved flying performance. The present invention is predicated on this finding.

According to the present invention, there is provided a solid golf ball comprising a rubber composition containing a base rubber; an unsaturated carboxylic acid metal salt, and a sulfur compound selected from the group consisting of an organic sulfur compound and a metal-containing organic sulfur compound.

In one form, the ball is a one-piece golf ball which is entirely formed of the present rubber composition.

In another form, the ball is a multi-layered golf ball comprising a core and a cover enclosing the core, wherein the core is formed of the present rubber composition. The core may be enclosed in the cover directly or through an intermediate layer,

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BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a cross section of a one-piece golf ball. FIG. 2 is a cross section of a two-piece golf ball.

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DETAILED DESCRIPTION OF THE INVENTION

FIG. 1 shows in cross section a one-piece golf ball 11.

FIG. 2 shows a two-piece golf ball 21 comprising a core 23 coated with a cover 25. A plurality of, usualy 200 to 600, dimples are formed on the surface of the golf balls, although they are not shown in FIGS. 1 and 2.

The solid golf ball of the present invention is a onepiece golf ball or a multi-layered golf ball in which the one-piece golf ball or the core of the multi-layered golf ball is formed from a rubber composition comprising a base rubber, an unsaturated carboxylic acid metal salt, and an organic sulfur compound and/or a metal-containing organic sulfur compound.

The base rubber used herein may be any desired rubber which is commonly used in conventional one-piece golf balls and cores of multi-layered golf balls. Polybutadiene rubbers, especially poly(1,4-butadiene) rubbers containing at least 40 mol%, preferably 80 to 100 mol% of cis-1,4 bond are preferred because of high rebound resilience, extrusion moldability, and high strength after vulcanization. If desired, the poly(1,4-butadiene) rubbers may be blended with natural rubber, polyisoprene rubber, styrene-butadiene rubber or the like. It is desired that at least 80% by weight of poly(1,4-butadiene) rubber be present in the base rubber because base rubbers containing less amounts of poly(1,4-butadiene) rubber often fail to take advantage of the rebound resilience of polybutadiene rubber.

The metal salt of unsaturated carboxylic acid is blended as a co-crosslinking agent. Examples include zinc and magnesium salts of unsaturated fatty acids having 3 to 8 carbon atoms, such as acrylic acid, methacrylic acid, maleic acid, and fumaric acid, with the zinc salts of acrylic and

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methacrylic acid being most preferred. The unsaturated carboxylic acid metal salt may be blended in a rubber either as a preformed metal salt or by introducing an α,β -unsaturated carboxylic acid and a metal oxide or hydroxide into the rubber composition and allowing them to react in the rubber composition to form a metal salt. The unsaturated carboxylic acid metal salt may be blended in any desired amount, but preferably in amounts of about 25 to about 40 parts by weight per 100 parts by weight of the base rubber.

The rubber composition used in the manufacture of the solid golf ball of the invention contains an organic sulfur compound and/or a metal-containing organic sulfur compound in addition to the base rubber and the unsaturated carboxylic acid metal salt. Examples of the organic sulfur compound include thiophenols such as pentachlorothiophenol, 4-t-butyl-o-thiocresol, 4-t-butyl-p-thiocresol, and 2benzamidothiophenol, thiocarboxylic acids such as thiobenzoic acid, and sulfides such as dixylyl disulfide, di(obenzamidophenyl) disulfide and alkylated phenol sulfides. Examples of the metal-containing organic sulfur compound include zinc salts of the above-mentioned thiophenols and thiocarboxylic acids. The sulfur compounds may be used alone or in admixture of two or more of them. The sulfur compound is preferably blended in amounts of from about 0.05 to about 2 parts by weight, more preferably from about 0.1 to about 0.5 parts by weight per 100 parts by weight of the base rubber.

The rubber composition of the invention may further contain a co-crosslinking initiator. Preferred examples of the co-crosslinking initiator include organic peroxides, such as dicumyl peroxide, t-butylperoxybenzoate, di-t-butylperoxide, 1,1-bis(t-butylperoxy)-3,3,5-trimethyl-cyclohexane, n-butyl-4,4-bis(t-butylperoxy)valerate, 2,2'-

cyclohexane, n-butyl-4,4-bis(t-butylperoxy)valerate, 2,2'35 bis(t-butylperoxy-isopropyl)benzene, and 2,5-dimethyl-2,5di(t-butylperoxy)hexene, with the dicumyl peroxide being

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most preferred. The initiator may be blended in amounts of about 0.5 to about 3 parts by weight, preferably about 1 to about 2.5 parts by weight per 100 parts by weight of the base rubber.

Also employable is a filler. Preferred examples of the filler include metal oxides such as zinc oxide and magnesium oxide. It may be blended in amounts of about 10 to about 80 parts by weight per 100 parts by weight of the base rubber. If desired, the rubber composition can additionally contain a plasticizer, an antioxidant, and any other additives which are generally employed in the preparation of one-piece balls or cores of multi-layered balls. Their amounts may be determined without undue experimentation.

The solid golf ball of the invention may be prepared by molding the above formulated rubber composition as formulated above into a desired spherical shape, that is, a ball in the case of a one piece ball or into a core in the case of a multi-layered ball and vulcanizing the rubber by heating. The manufacture may be in accord with conventional method and conditions.

When multi-layered golf balls such as two-piece balls are manufactured, the core is coated with a cover. The cover material used herein may be selected from commonly used cover materials, for example, ionomers such as Surlyn $^{\circ}$, polyesters, and nylons. The cover usually has a thickness of 0.5 to 2.5 mm.

The core may be enclosed in the cover directly or through an intermediate layer.

The present invention may be applied to any type of golf ball including small balls having a diameter of at least 41.15 mm and a weight of up to 45.92 g, and large balls having a diameter of at least 42.67 mm and a weight of up to 45.92 g.

The distribution and total number of dimples are not critical although 300 to 550 dimples, preferably 350 to 540 dimples are generally formed on a ball. Preferred dimple

IN UNITED STATES DISTRICT COURT DISTRICT OF DELAWARE

BRIDGESTONE SPORTS CO., LTD., AND BRIDGESTONE GOLF, INC.,

Plaintiffs.

C.A. No. 05-132(JJF)

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ACUSHNET COMPANY,

Defendant.

PLAINTIFFS' EIGHTH SUPPLEMENTAL RESPONSES TO DEFENDANT'S FIRST SET OF INTERROGATORIES

Pursuant to Rule 33 of the Federal Rules of Civil Procedure, Plaintiffs Bridgestone Sports' Co., Ltd., and Bridgestone Golf, Inc., (individually or collectively "Bridgestone") hereby supplements its responses to Defendant's First Set of Interrogatories to Plaintiff.

GENERAL OBJECTIONS

The General and Specific Objections set forth in Plaintiff's: First Responses to Defendant's First Set of Interrogatories; Plaintiff's First Supplemental Responses to Defendant's First Set of Interrogatories; Plaintiff's Second Supplemental Responses to Defendant's First Set of Interrogatories; Plaintiff's Third Supplemental Responses to Defendant's First Set of Interrogatories; and Plaintiff's Fourth Supplemental Responses to Defendant's First Set of Interrogatories; Plaintiff's Fifth Supplemental Responses to Defendant's First Set of Interrogatories; and Plaintiff's Sixth Supplemental Responses to Defendant's First Set of Interrogatories, are incorporated herein by reference.

Bridgestone reserves the right to later amend or supplement its contentions after further investigation and discovery and after the Court construes the claims.

Subject to, and without waiving, any of the General and Specific Objections, Bridgestone hereby supplements its responses to Interrogatory Nos. 6 and 21.

Document 252-2

OBJECTIONS AND RESPONSES

INTERROGATORY NO. 6

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Identify on a claim-by-claim basis, for each claim of the Bridgestone Patents identified in your responses to interrogatory No. 1 above, any alleged dates of conception; any alleged subsequent diligence until reduction to practice; any alleged dates of actual reduction to practice of the claimed invention; any written descriptions or drawings of the claimed invention prepared prior to the filing date; the date of the first constructive reduction to practice of the subject matter defined by the claim; the names, titles, and place of work (at the time of their involvement and current) of all persons who were involved in connection with such conception, diligence, or reduction to practice; and the earliest effective filing date Bridgestone will assert for each such claim. State in detail all factual bases supporting Bridgestone's identification of each such date, and identify all persons, documents, and tangible things corroborating each such date.

RESPONSE TO INTERROGATORY NO. 6

In addition to the General Objections, Bridgestone objects to the interrogatory as being a multiple and compound request constituting more than one interrogatory. Bridgestone also objects to the interrogatory as being overly broad, unduly burdensome, oppressive, not being limited in subject matter and/or scope to issues in the case, and seeking information that is neither relevant to this case nor reasonably calculated to lead to the discovery of admissible evidence.

Subject to and without waiving the general and specific objections, Bridgestone will produce, pursuant to Fed. R. Civ. P. 33(d), non-privileged documents responsive to the interrogatory sufficient to permit Acushnet to determine an answer as readily as Bridgestone.

In addition, Bridgestone further supplements its previous responses as follows:

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U.S. Patent No. 5,252,652

For any claim of the '652 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is May 10, 1990, which is the filing date on the face of the '652 patent.

For any claim of the '652 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is May 11, 1989, based on JP 1-118460.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 202885-202916.

U.S. Patent No. 5,553,852

For any claim of the '852 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is Jul. 8, 1994, which is the filing date on the face of the '852 patent.

For any claim of the '852 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is July 8, 1993, based on JP 5-193065.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203021-203070.

U.S. Patent No. 5,695,413

For any claim of the '413 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is Apr. 19, 1996, which is the filing date on the face of the '413 patent.

For any claim of the '413 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is April 26, 1995, based on JP 7-125966.

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Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203128-203164.

U.S. Patent No. 5,743,817

For the claims of the '817 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is Sep. 29, 1995, which is the filing date on the face of the '817 patent.

For the claims of the '817 patent, the earliest dates of invention Bridgestone will assert for purposes of the instant action is October 14, 1994, based on JP 6-276109.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203200-203250.

U.S. Patent No. 5,782,707

For any claim of the '707 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is Mar. 10, 1997, which is the filing date on the face of the '707 patent.

For any claim of the '707 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is March 11, 1996, based on JP 8-082121.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203287-203342.

U.S. Patent No. 5,803,834

For any claim of the '834 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is Feb. 27, 1997; which is the filing date on the face of the '834 patent.

For any claim of the '834 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is March 1, 1996, based on JP 8-071135.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203371-203415.

U.S. Patent No. 5,813,924

For any claim of the '924 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is the Sept. 29, 1995 filing date of the '817 patent, which is indicated to be the parent of the '924 patent on its face.'

For any claim of the '924 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is October 14, 1994, based on JP 6-276109.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203200-203250 and 203436-203458.

U.S. Patent No. 6,634,961

For any claim of the '961 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is May 30, 2002, which is the filing date on the face of the '961 patent.

For any claim of the '961 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is May 30, 2001, based on JP 2001-163238.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203488-203520 and 203578-203606.

U.S. Patent No. 6,679,791

For any claim of the '791 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is June 15, 2001, which is the filing date on the face of the '791 patent.

For any claim of the '791 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is June 26, 2000, based on JP 2000-190640.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203656-203698.

U.S. Patent No. 6,780,125

For any claim of the '125 patent, the earliest effective U.S. filing date Bridgestone will assert for purposes of the instant action is September 11, 1997, which is the filing date of Provisional Application 60/058,563, from which the '125 patent claim priority on its face.

For any claim of the '125 patent, the earliest date of invention Bridgestone will assert for purposes of the instant action is August 11, 1997, based on JP 9-228902.

Pursuant to Fed. R. Civ. Pro. 33(d), Bridgestone further responds in view of BSP 203787-203870.

Bridgestone's indications of earliest effective filing date, earliest effective US filing date, and earliest date of invention for each patent are based on the current invalidity assertions of Acushnet, and therefore may not accurately reflect the earliest possible date to which Bridgestone is entitled to rely in this or other actions.

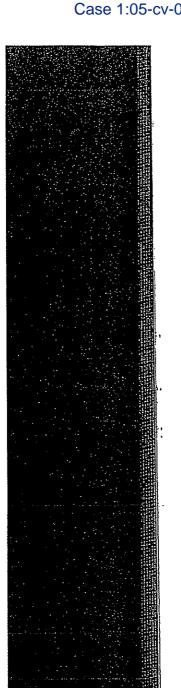
Further, Bridgestone's investigation is ongoing. Therefore, Bridgestone reserves the right to amend or supplement its response after further investigation, and based on positions taken by, or contentions of Acushnet



Merriam-Webster's Collegiate' Dictionary

TENTH EDITION

Merriam-Webster, Incorporated Springfield, Massachusetts, U.S.A.





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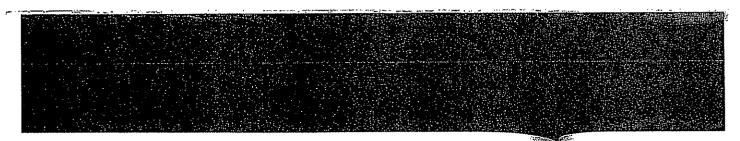
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NASA NEWS

Oct. 24, 2003

John Ira Petty Johnson Space Center (281) 483-2530

Release: #J03-109

NASA SCIENTIST MAKES SCIENCE AND MATH ACCESSIBLE

NASA math whiz and computer software designer Robert O. Shelton considers himself lucky, ϵ though he lost his sight when he was 11-years-old. He felt lucky to have parents and teachers a spotted his talent in mathematics and science, encouraged him, and provided tools that helped pursue his interest.

Shelton was born with congenital glaucoma, a disease that is usually treatable with today's last technology but was hard to cure in the 1950s, when Shelton was a child. After suffering through operations, he said, "It was almost a relief to lose my sight and have it over with."

"Before I lost my sight, I was a smart kid, but rather sloppy," Shellon said. "My mother told me, going to have to use different muscles now — the ones between your ears. She was tough on r said I could do whatever I wanted, but I would have to work even harder because I was blind," added.

As a child in Houston, Shelton enjoyed working with his father, an electrical engineer, tinkering family garage, building things and tearing them apart to see how they worked. After losing his s continued that trend in a new way — learning mathematical equations and scientific laws that exthings work. His teachers helped him study advanced mathematics and science and taught him visualize concepts in his mind.

Shelton earned bachelor's, master's and doctorate degrees in mathematics from Rice Universit Houston in 1971, 1973 and 1975, respectively. While at Rice, he was a graduate intern at the J Space Center (JSC), Houston. He worked with computer scientists and engineers designing the navigation system for the Space Shuttle.

"NASA has always been committed to hiring individuals with disabilities," Shelton said. "They p me with the help and technology I needed to do the job, and made it seem simple."

When NASA offered him a job working on artificial intelligence systems in 1987, Shelton, his wifour children returned to Texas. He joined the JSC Software Technology Branch, designing contechnology used to analyze data sent from the Space Shuttle to the Mission Control Center in F

Shelton uses his math and computer expertise to head up JSC's contributions to NASA's Learr Technologies Project. He works on technology tools for teachers and students in kindergarten to 12th grade. The tools are available through Web sites, and Shelton's leadership has ensured a accessible to students with disabilities.

"i want blind and sighted students who use the site to find out what they can do," Shelton said. teachers to have easy-to-use, cutting-edge technology tools that make math and science access tudents. Most importantly, I want employers to emulate NASA by hiring blind people and using talents, "he added.

Shelton believes using NASA technology and know-how to reach people with disabilities is a rematch. Improved technology, such as synthetic speech software that reads content, has helped

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more independent as he works.

The Web site is filled with appealing activities: students can build, test and run a remotely contr In simulated environments and compete in skill-based games against other students around the The site also offers software tools that make it easier for teachers to manage information relate science and math curricula. Shelton's creative team is working on a new product that will be av soon: a graphing tool to make NASA science and math activities accessible to people who can't uses tones to help blind people visualize graphs and mathematic concepts.

According to Shelton the unemployment rate for blind people is high and many who are employ working at jobs that fully use their education or potential. He hopes the NASA Web site will help learn valuable skills to improve employment prospects.

Media organizations interested in interviewing Shelton should contact John Ira Petty, JSC Publ at (281)4B3-5111.

To access the NASA Learning Technologies Project on the Internet, visit:

http://prime.jsc.nasa.gov



- + Inspector General Hotline
- + Equal Employment Opportunity Data Posted
- Pursuant to the No Fear Act
- + FY 2005 Budget Request
- + 2003 Strategic Plan
- + Freedom of Information Act
- + The President's Management Agenda
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